

Work Order ID 128933

Tuesday, January 27, 2015 7:54:38 AM

128933

Page 1

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft X-Tube Lug Ass'Y
 Start Date: 1/26/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-01-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4149	C								

100 0.00 ***100*** DAS 36 9-89
 Small Fab Memo 0.00 2
 Small Fab 1- Assemble as per dwg 15/03/08

110 QC5- Inspect part completeness to step on W/O 0.00
110 QC Memo 0.00 (2) DAS 36 9-89
 Quality Control MAR 10 2015

120 Identify as per dwg & Stock Location: U 53A 0.00
120 Packaging Memo 0.00 (2) YMF 15-3-10
 Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-11
MF
15-3-10-

DQA: _____ Date: _____



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Supplier									
Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Page 1

Work Order ID: 128933

128933

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3 *MS21043-3* Nut		Purchased	No			100	Each	1,289.000	4	4		15/03/09	DAS 36 9-89

Location	Loc Qty	Loc Code
FG	80	
103691	80	
FP001	179	
m130673	179	
GA	30	
m130673	30	
ST304	1000	
m131340	1000	

MS21043-4

Purchased

No

100

Each

1,187.000

1

6

MS21043-4

Nut

15/03/09

DAS
36
9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	502	
m128798	502	
ST304	645	
m128798	611	
m128818	34	

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Doc/Data									
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Work Order ID: 128933

128933

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

D3910-1 Manufactured No

100 Each 17.0000 1 2

D3910-1

Crosstube Lug

**

15/03/09

DAS

36
9-89

Location

Loc Qty

Loc Code

ST524

17

114443

17

2

D4091-1 Manufactured No

100 Each 0.0000 1 2

D4091-1

D4091-1

Mounting Lug

B128425 (2x)**

15/03/09

DAS
36
9-89

D4149-1

Manufactured No

100 Each 12.0000 2 4

D4149-1

Crosstube Lug Plate, Aft

**

15/03/09

DAS
36
9-89

Location

Loc Qty

Loc Code

ST094

1

125697

1

ST103a

11

126334

11

4

D4149-3

Manufactured No

100 Each 7.0000 1 2

D4149-3

Spacer

**

15/03/09

DAS
36
9-89

Location

Loc Qty

Loc Code

ST094

7

127553

7

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

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Work Order ID: 128933

128933

Parent Item: D4149-041

D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

D4149-5

Manufactured No

100

Each

15.0000

1

2

D4149-5

Eyebolt Stud

DAS
36
9-85

15/03/09

Location

Loc Qty

Loc Code

ST093

4

127412

4

ST094

7

121475

1

128422

6

ST103a

4

122937

4

2

AN3C12A

Purchased

No

100

Each

324.0000

2

4

AN3C12A

Bolt

DAS
36
9-8.

15/03/09

Location

Loc Qty

Loc Code

GA

231

M128727

231

ST349

93

M128727

93

4

AN4C13A

Purchased

No

100

Each

27.0000

3

6

AN4C13A

BOLT

DAS
36
9-89

15/03/09

Location

Loc Qty

Loc Code

GA

7

m128818

7

ST344

20

m128818

20

1131677

6x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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D4149-041

Parent Item Name: Aft X-Tube Lug Ass'Y

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18

Purchased

No

100

Each

707.0000

3

6

MS20615-4M18

Rivet

DAS
36
9-89

15/03/09

Location

Loc Qty

Loc Code

CCK003

370

m123810

370

GA

230

m130358

230

ST307

107

125162

107

NAS1149C0332R

Purchased

No

100

Each

4,938.000

4

8

NAS1149C0332R

WASHER

DAS
36
9-89

15/03/09

Location

Loc Qty

Loc Code

FP001

2178

m130325

2178

GA

26

125654

26

ST271

2734

125654

44

m130466

690

m131340

2000

NAS1149C0432R

Purchased

No

100

Each

1,597.000

6

12

NAS1149C0432R

WASHER

DAS
36
9-89

15/03/09

Location

Loc Qty

Loc Code

GA

1508

m125807

1508

ST271

89

m125807

89

M131 ⁴⁶⁷ ~~127~~ (12x)

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Shop Packet Print

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DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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